

Date: Wednesday, 17/10/2007 1:28:24 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE	
Job Number	: 35186		Part Number	: D2889	
Estimate Number	: 10006		Drawing Number	: D2889 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 17/10/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 24/10/2007 Qty: 1 Um: Each	
Previous Run	: 35185				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 05-10-25 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube material
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube <u>B23963</u> <i>X</i>		
2.0	BENDING	BENDING MACHINE
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001		
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE 1 <i>N/A</i>		
1-Deburr and Polish		
4.0	QC6	DIMENSIONAL CHECK
<i>7-10-22</i>		
<b>Comment:</b> DIMENSIONAL CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube		
<i>N/A</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/06/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/10/2007 1:28:24 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 35186

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*N/A*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W1034946

*107-10-22* *0*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10710123*

Job Completion



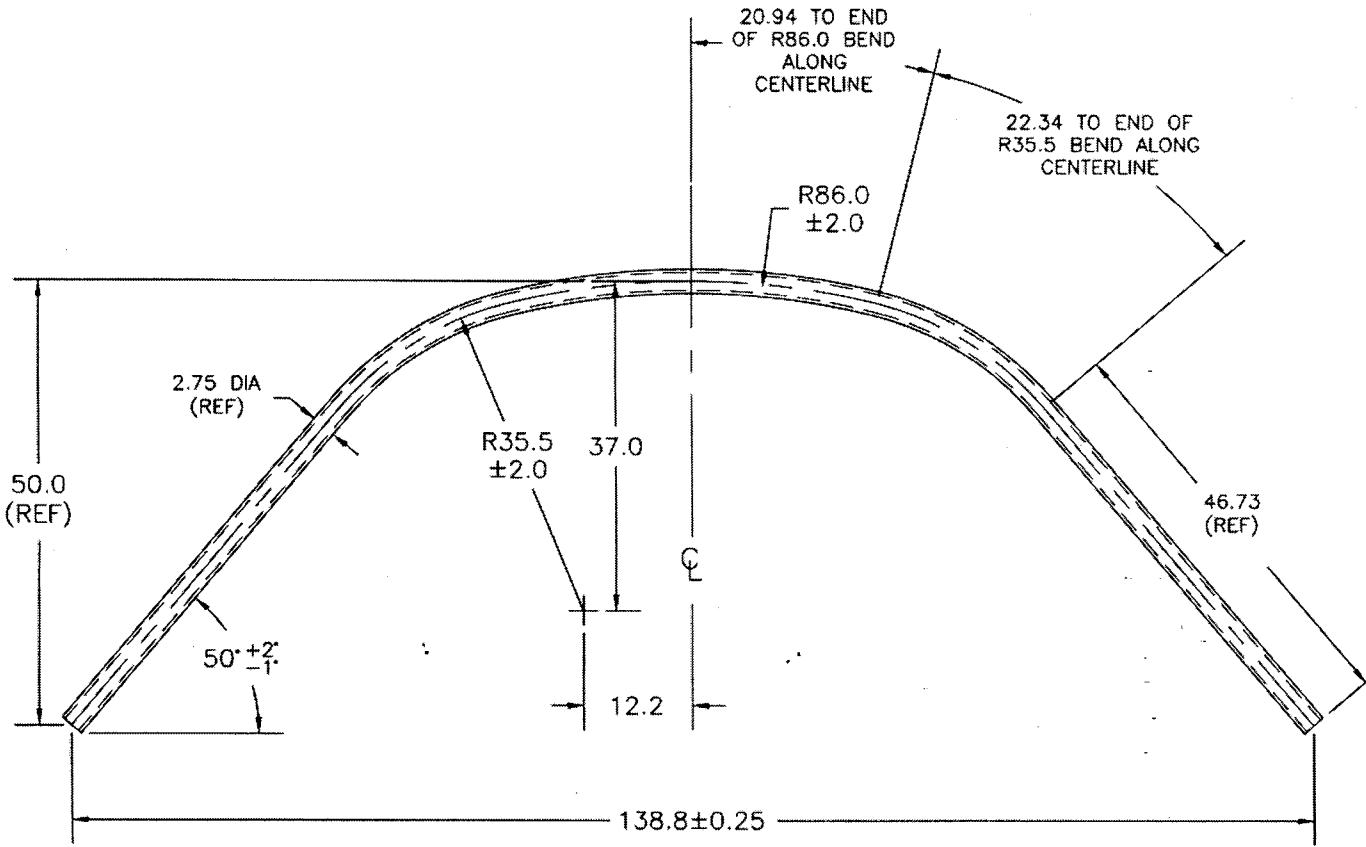
*L 07-10-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
02.10.28

DART  
DRAFT  
02/10/28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV.
✓	✓	D2889	B
DATE		TITLE	SHEET 1 OF 1
02.10.18		FWD CROSSTUBE	1:20
A	99.05.21	NEW ISSUE	SCALE
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

35186

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\phi 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 35186

Description: Crosstube Fwd

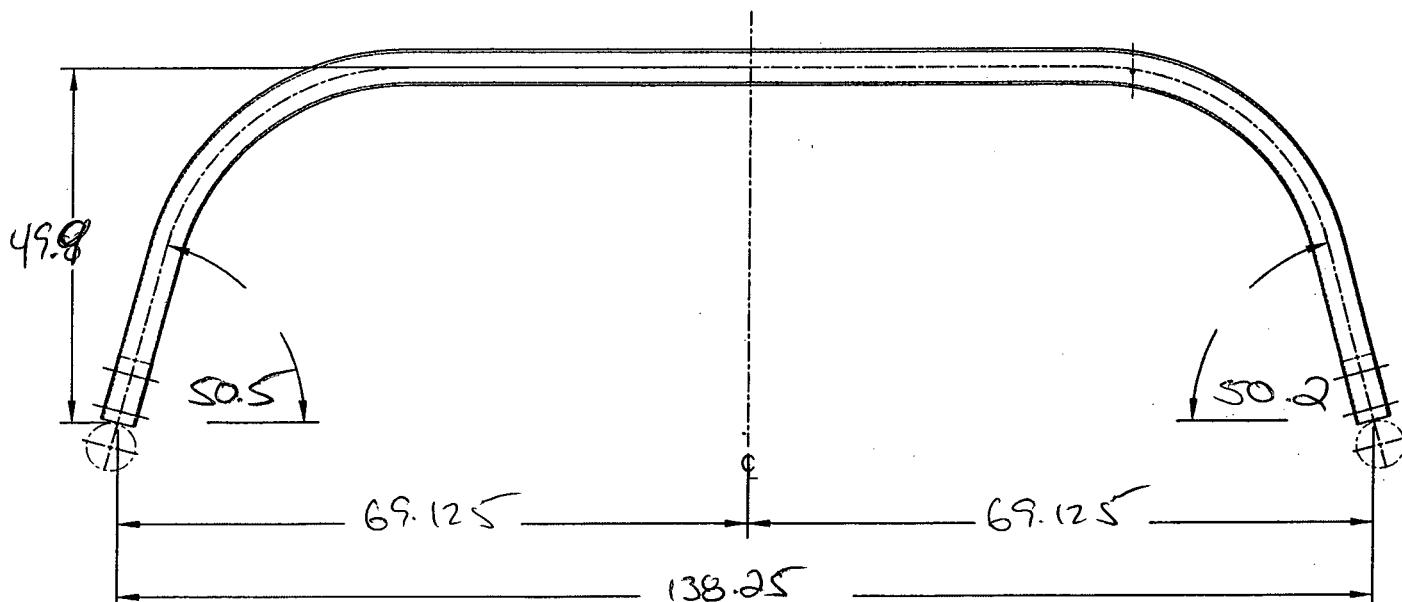
Part Number: D2889

Inspection Dwg: D2889

Rev: B

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Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is Perfect for D205-556-101 B34946

QC15 Inspection	<i>J</i>
Date	04-10-22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>J</i>

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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